

Work Order ID 136320

September 02, 2015 11:11:02 AM

136320

Page 1

Item ID: D5203-041 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Strut Assembly
 Start Date: 9/2/2015 Start Qty: 2 ***1*** Cust Item ID:
 Required Date: 9/9/2015 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: SH Date: 20150907 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D5203	A								

100 0.00
100
 Small Fab Memo 0.00 2 FF SEP 07 2015
 Small Fab ASSEMBLE AS PER DWG AND TORQUE NUTS AS PER NOTE 8.

110 QC5- Inspect part completeness to step on W/O 0.00
110
 QC Memo 0.00 (2) SEP 07 2015
 Quality Control

120 Identify as per dwg & Stock Location: SB370 0.00
120
 Packaging Memo 0.00 2 SEP 08 2016 DAS
 Packaging 8
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition				Completed By																	
10-10-2022								Lead hand / Supervisor Approval Verification																	
								QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐																				
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____																							
Misidentified ☐	Past Due ☐																								

Work Order ID 136320

September 02, 2015 11:11:02 AM

136320

Page 2

Item ID: D5203-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Strut Assembly

Stop ***NS2***

Start Date: 9/2/2015 Start Qty: 1.00

1

Cust Item ID:

Required Date: 9/9/2015 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

QC21- Final Inspection - Work Order Release

0.00

130DAS
21
9-89

SEP 08 2016

QC

Memo

0.00

Quality Control

DAS
21
9-89

SEP 08 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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OTHER : _____																																																																				

Picklist Print

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Page 1

Work Order ID: 136320

136320

Parent Item: D5203-041

D5203-041

Parent Item Name: Strut Assembly

Start Date: 9/2/2015

Required Date: 9/9/2015

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 15.01.08 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN3C3A		Purchased	No				Each	375.0000		2			
AN3C3A									**		FF	SEP 14 2015	
Bolt													

Location	Loc Qty	Loc Code
GA	101	
124417	1	
m132930	100	
ST338a	100	
m132930	100	
ST350	174	
131677	174	

SEP 07 2016
FF
M 135058
(2)

D2690-6		Manufactured	No				Each	36.0000		2			
D2690-6									**		FF	SEP 14 2015	
Lanyard													

Location	Loc Qty	Loc Code
ST009	36	
134004	10	
135768	26	

SEP 07 2016
148320 FF
(2)

D5203-045		Manufactured	No				Each	0.0000		1			
D5203-045									**		DAS 30 9-89	SEP 07 2016	
Strut Weldment													

MS17984-C405		Purchased	No				Each	2.0000		2			
MS17984-C405									**		FF	SEP 14 2015	
Pin, Quick Release													

Location	Loc Qty	Loc Code
ST315	2	
M131584	2	

SEP 07 2016
FF
M146282
M134676
(1)
(2)

Picklist Print

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Page 2

Work Order ID: 136320

136320

Parent Item: D5203-041

D5203-041

Parent Item Name: Strut Assembly

Start Date: 9/2/2015

Required Date: 9/9/2015

Start Qty: 1.00

Required Qty: 1.00

MS21043-3

Purchased

No

Each

1,034.000

2

MS21043-3

**

FF

SEP 14 2015

Nut

Location

Loc Qty

Loc Code

FG 80

103691 80

FP001 11

m130673 11

GA 187

SEP 07 2016 FF M133990 ②

m130673 15

m131677 172

ST304 699

m131340 199

m133031 500

ST308 57

m132551 57

MS21919WCF8

Purchased

No

Each

10.0000

2

MS21919WCF8

**

FF

SEP 14 2015

Clamp

Location

Loc Qty

Loc Code

ST297 10

M134634 ②

M129947 10

September 02, 2015 11:11:09 AM

Shop Packet Print

Page 2

Picklist Print

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Page 3

Work Order ID: 136320

136320

Parent Item: D5203-041

D5203-041

Parent Item Name: Strut Assembly

Start Date: 9/2/2015

Required Date: 9/9/2015

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0332R

Purchased

No

Each

4,303.000

4

NAS1149C0332R

FF

SEP 14 2015

WASHER

Location

Loc Qty

Loc Code

FP001

3994

m130325

2110

m132930

1884

GA

m131618

207

207

ST271

102

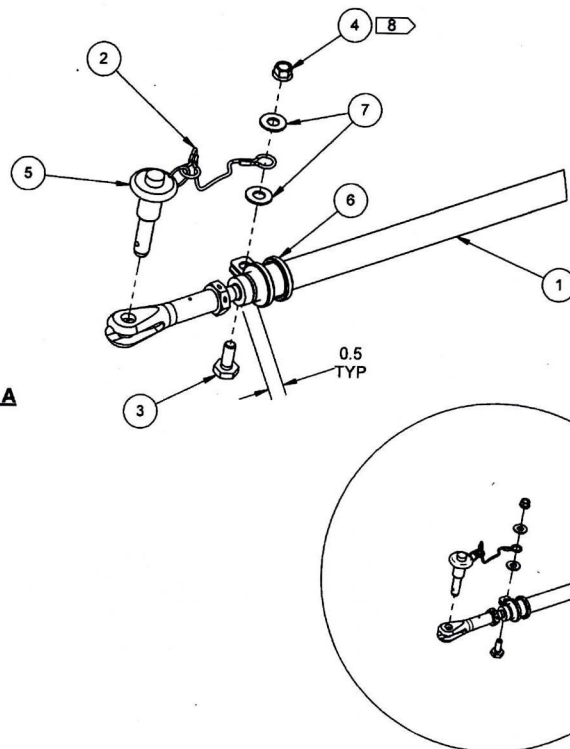
m129390

72

m132262

30

DETAIL A



D5203-041 STRUT ASSEMBLY

ITEM	QTY	P/N	DESCRIPTION
	X	D5203-041	STRUT ASSEMBLY
1	1	D5203-045	STRUT WELDMENT
2	2	D2690-6	LANYARD ASSEMBLY
3	2	AN3C3A	BOLT
4	2	MS21043-3	NUT, SELF-LOCKING
5	2	MS17984-C405	PIN, QUICK RELEASE (NASM17984-C405)
6	2	MS21919WCF8	CLAMP
7	4	NAS1149C0332R	WASHER

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
 - 7) WEIGHT: 0.95 lbs
 - 8) TORQUE NUTS TO 20-25 in-lb

RELEASED

2015 JAN 29

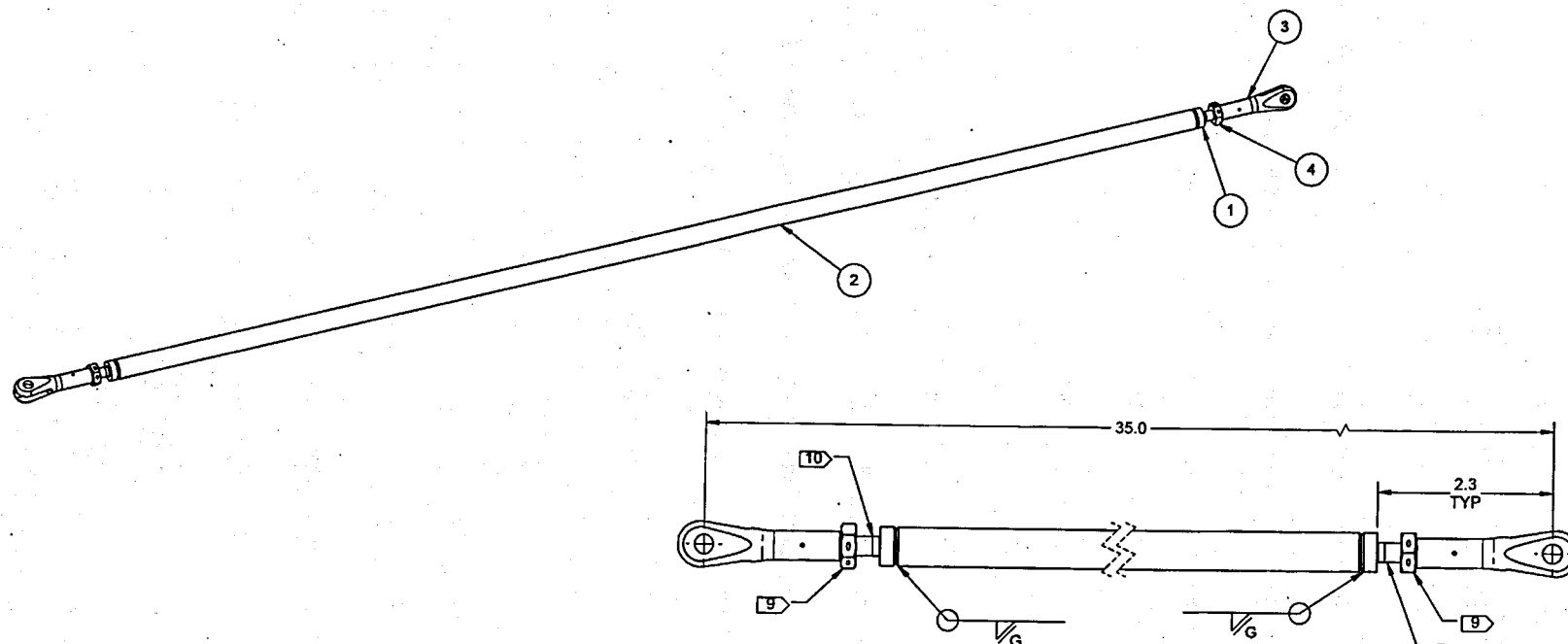
ECN 15-508 4

SA 136320 20150902

A	NEW ISSUE	RF	14.12.19
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	VS	DRAWING NO.	REV. A
MFG. APPR.	DD	D5203	SHEET 1 OF 6
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	STRUT ASSEMBLY	NTS
DATE	14.12.19	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

APPROVED

ITEM	QTY -045	P/N	DESCRIPTION
	X	D5203-045	STRUT WELDMENT
1	2	D4794-3	STUD
2	1	D5203-1	STRUT
3	2	AN665-34R	THREADED CLEVIS
4	2	NAS509-4C	NUT, JAM



D5203-045 STRUT WELDMENT

RELEASED
2015 JAN 29 *up*

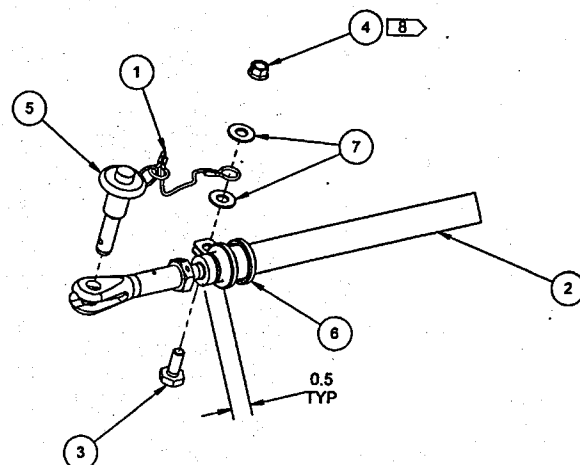
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.82 lbs
- 8) WELD PER DART QSI 004
- 9) HAND TIGHTEN NAS509-4C NUT
- 10) USE TECTYL 502C CLASS I, MIL-PRF-16173E GRADE 2 OR EQUIVALENT ANTI-SEIZE COMPOUND ON THREAD

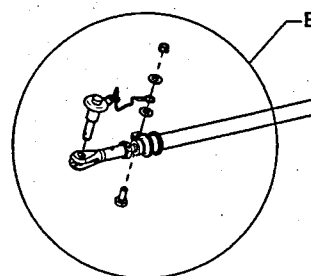
APPROVED

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	VS	DRAWING NO.	REV. A
MFG. APPR.	DD	D5203	SHEET 2 OF 8
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	STRUT ASSEMBLY	NTS
DATE	14.12.19	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

ITEM	QTY -043	P/N	DESCRIPTION
	X	D5203-043	STRUT ASSEMBLY
1	2	D2690-6	LANYARD ASSEMBLY
2	1	D5203-047	STRUT WELDMENT
3	2	AN3C3A	BOLT
4	2	MS21043-3	NUT, SELF-LOCKING
5	2	MS17984-C405	PIN, QUICK RELEASE (NASM17984-C405)
6	2	MS21919WCF8	CLAMP
7	4	NAS1149C0332R	WASHER



DETAIL B



D5203-043 STRUT ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 1.19 lbs
- 8) TORQUE NUTS TO 20-25 In-lb

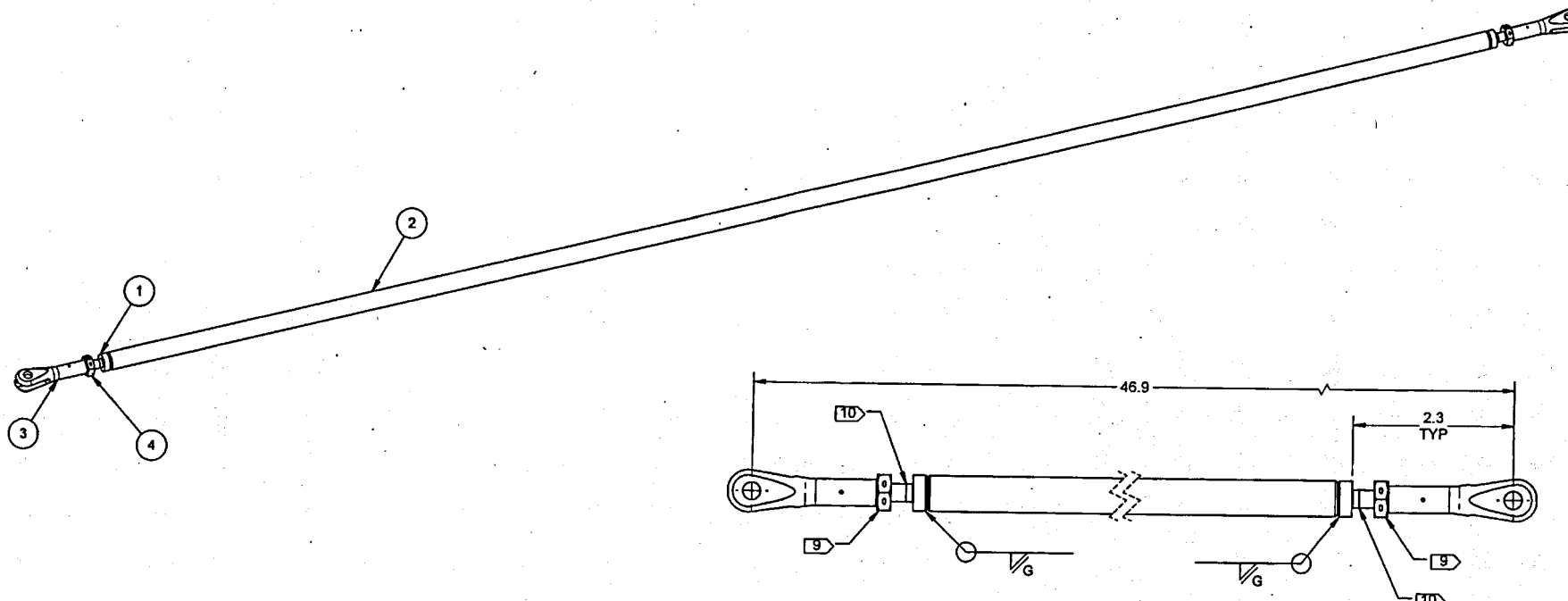
RELEASED

2015 JAN 29 *qp*

APPROVED

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	VS	DRAWING NO.	REV. A
MFG. APPR.	DD	D5203	SHEET 3 OF 6
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	STRUT ASSEMBLY	NTS
DATE	14.12.19	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

ITEM	QTY -047	P/N	DESCRIPTION
	X	D5203-047	STRUT WELDMENT
1	2	D4794-3	STUD
2	1	D5203-3	STRUT
3	2	AN885-34R	THREADED CLEVIS
4	2	NAS509-4C	NUT, JAM



D5203-047 STRUT WELDMENT

RELEASED
2015 JAN 29

- NOTES:**
- 1) MATERIAL: N/A
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 1.06 lbs
 - 8) WELD PER DART QSI 004
 - 9) HAND TIGHTEN NAS509-4C NUT
 - 10) USE TECTYL 502C CLASS I, MIL-PRF-16173E GRADE 2 OR EQUIVALENT ANTI-SEIZE COMPOUND ON THREAD

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DRAWN	RF		
CHECKED	VS	DRAWING NO.	REV. A
MFG. APPR.	DD	D5203	SHEET 4 OF 6
APPROVED	HS	TITLE	SCALE
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0.030 x 45°
CHAMFER
2 PL

Q

30.07

Ø0.500
REF

0.049
REF

D5203-1 STRUT

RELEASED

2015 JAN 29 *ap*

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SEAMLESS ROUND TUBING
PER ASTM A213 OR ASME SA213 OR ASTM S269
REF DART SPEC M304TR0.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.60 lbs

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DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	VS	DRAWING NO.	REV. A
MFG. APPR.	DD	D5203	SHEET 5 OF 8
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	STRUT ASSEMBLY	NTS
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0.030 x 45°
CHAMFER
2 PL

Ø

42.00

Ø0.500
REF

0.049
REF

D5203-3 STRUT

RELEASED

2015 JAN 29 *ap*

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SEAMLESS ROUND TUBING
PER ASTM A213 OR ASME SA213 OR ASTM S269
REF DART SPEC M304TR0.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.84 lbs

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DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	VS	DRAWING NO.	REV. A
MFG. APPR.	DD	D5203	SHEET 6 OF 6
APPROVED	HS	TITLE	SCALE
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